



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-241
Job Sheet 166774-A



Part No: D119-646-241

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 11/10/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

FIN-D119-646 REV A
A3887 REV E

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
110	Skidtubes	1 pcs		11/9/17	0.77	0.05	Skidtubes	<i>J.Y.</i>
120	HandFinish	1 pcs		11/9/17	0.00	0.79	HandFinish1	<i>J.Y.</i>
121	QC	1 pcs		11/9/17	0.00	0.00	QC7	<i>BE</i>
122	QC	1 pcs		11/9/17	0.00	0.00	QC5	<i>BE</i>
130	Skidtubes	1 pcs		11/9/17	0.00	2.38	Skidtubes	<i>J.Y.</i>
135	QC	1 pcs		11/9/17	0.00	0.00	QC5	<i>BE</i>
140	Skidtubes	1 pcs		11/9/17	0.00	2.38	Skidtubes	<i>J.Y.</i>
150	QC	1 pcs		11/9/17	0.00	0.00	QC5	<i>BE</i>
160	Skidtubes	1 pcs		11/9/17	0.00	2.44	Skidtubes	<i>BE</i> <i>mlg</i>
170	QC	1 pcs		11/9/17	0.00	0.00	QC5	<i>38</i> <i>DAS</i>
180	QC	1 pcs		11/9/17	0.00	0.00	QC10	<i>9-88</i> <i>38</i>
190	HandFinish	1 pcs		11/9/17	0.00	0.33	HandFinish2	<i>SA</i> <i>15-03-08</i>
200	Powdercoat	1 pcs		11/9/17	0.00	0.20	Powdercoat1	<i>W</i> <i>15-3-02</i>
210	QC	1 pcs		11/9/17	0.00	0.00	QC3	<i>BE</i> <i>15-03-09</i>
240	HandFinish	1 pcs		11/9/17	0.00	0.79	HandFinish4	<i>BE</i> <i>15-03-09</i>
250	QC	1 pcs		11/9/17	0.00	0.00	QC5	<i>38</i>
255	HandFinish	1 pcs		11/10/17	0.00	0.20	HandFinish3	<i>BE</i> <i>18-03-12</i>
256	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>38</i>
258	DC	1 pcs		11/10/17	0.00	0.00	DC	<i>9-88</i>
260	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
270	QC21-FG	1 Ea		11/10/17	0.00	0.00	QC21	<i>DAS</i> <i>21</i> MAR 15 2018

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex-291 *1138535* Sikaflex expire date: *2018/04/21* Start: *8:20* Time: *8:35* Finish: *3:15* Time: *3:20* ***** (Adhere for 12 hours) *****

140 - 1- Bend FWD end of tube using bender 1 and bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurement*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size. (verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg 9- C'sink FWD cap hole as per detail "C" 10- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 11- Deburr and blow

S000845



PART NO: D119-646-241

Revision:

Operation: Start up Operation

Quantity: 1

Change No:

Mfg Date: 10/18/17

Job No: 166774--A

out chips from inside of tube.

160 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod
2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore x-bolt spacer holes as per Dwg D3887 using DT10279. 4-Deburr and blow out chips from inside of tub 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

170 - TEST FIT USING FIXTURE DT10091.

200 - ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____

240 - 1-Install wearplates as per Dwg D3887. 2-Inspect for foreign objects as per QSI 024 3-Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 M138761 Sikaflex expire date: 18/04 4

-Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291

M138761 Sikaflex expire date: 18/04

258 - Photocopy bluefile & type labels per PPP D119-646-241 CHG003

260 - Location : FG084

wing walk M138761

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-1-190 <u>159717</u>	1	138	0	0
140-Skidtubes	D2579 <u>M0500719</u>	2	56	0	0
	D3885-1 <u>B162935</u>	1	24	0	0
160-Skidtubes	D3681-1 <u>F163491</u>	12	136	0	0
	D3903-1 <u>B165654</u>	12	171	0	0
240-HandFinish	ALS4-1032-225 <u>S007280</u>	1	388	0	0
	AN3C46A <u>S006269</u>	8	175	0	0
	AN3C5A <u>S019396</u>	2	205	0	0
	D2855-3 <u>F153291</u>	1	42	0	0
	D2855-5 <u>6016439</u>	1	14	0	0
	D3402-045	8	48	0	0
	D3672-1 <u>F150074</u>	2	1,799	0	0
	D3849-041 <u>S036393</u>	1	3	0	0
	D3849-043 <u>S046298</u>	1	5	0	0
	D3904-1 <u>F165620</u>	16	144	0	0
	MS21043-3 <u>S016882</u>	8	917	0	0
	MS24694-C52 <u>FM137951</u>	2	101	0	0
	NAS1149C0332R <u>S044236</u>	2	2,674	0	0

Part Specifications

Specifications could not be found.

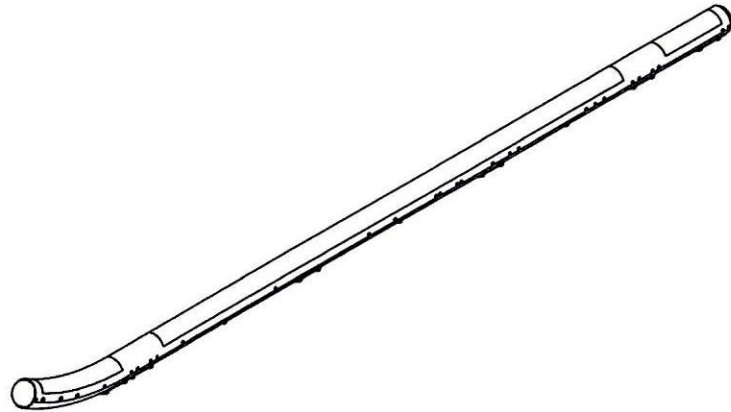
Plug D3492-5-S024248x8

Plex 10/17/17 2:46 PM dart.Michaud-Febrille.Victoria

O-ring NAS1611-005-S007808x8

001546

8 7 6 5 4 3 2 1

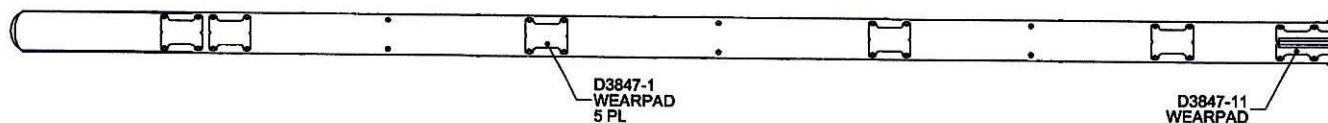
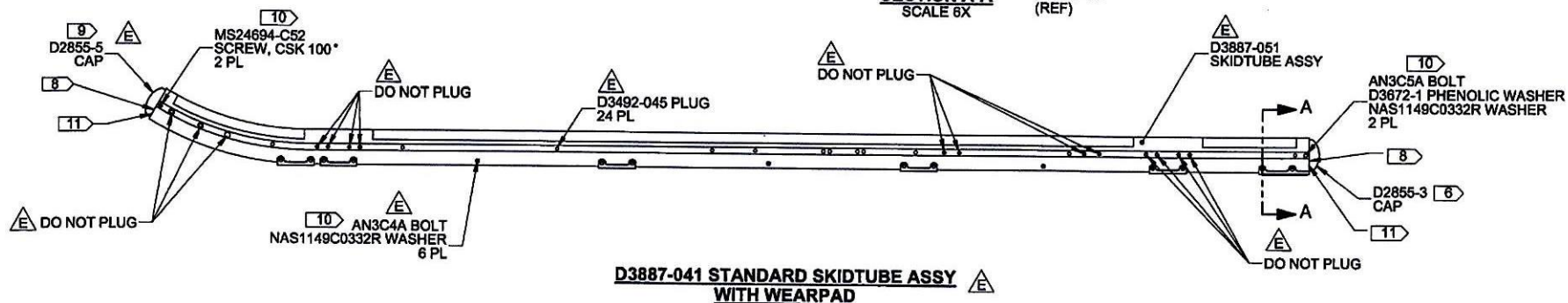
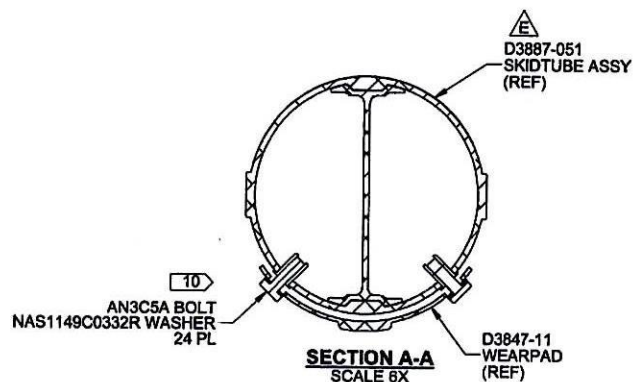


D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD(SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

E	COMPLETE REDRAW, ADDED ASSY DETAILS -3, -051 & -053, SEE PREVIOUS REV. FOR DETAIL. POWDER COAT REMOVED FROM SADDLE AREA SEE DETAIL F. REF PARTS-421. ADDED STRUCTURAL PROVISIONS TO ALLOW FOR THE INSTALLATION OF THE D119-846-313/314 SKIDTUBE PROTECTOR KIT. REF PART17-577. CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP, REF PART17-583	AJS / WK	17.02.03
D	REVISED BEND TOLERANCES FOR MANUFACTURABILITY, 135.07 WAS 134.04 (ZN D5-8), ADD 5.07 (ZN C2-3), ADD 118.8 (ZN D5-8), DELETE GASKETS (BOM, SH 2)	DB	13.09.20
C	(SHT1, P/L ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24694-C82 WAS AN3C5A, 2 PLCS (ZN C1-5, C1-6, B4-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.214 THRU, ADDED DETAIL F (ZN C2-5, C8-5, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A8-7)	DB	13.02.19
B	ALSA-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD DT8931 (ZN A8-1); ADD 134.04 (ZN C4-8); D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C8-2, C2-2, C6-3, C2-3, C8-4, C2-4); Ø0.313 WAS Ø0.328 (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE iv (ZN B3-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 1 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
DATE	17.02.03	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
 2017-05-08
 17-519

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3887-041	STANDARD SKIDTUBE ASSY WITH WEARPAD
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	24	D3492-045	PLUG ASSY
4	2	D3872-1	PHENOLIC WASHER
5	5	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3887-051	SKIDTUBE ASSY
8	1	ALS4-1032-225	INSERT
9	28	AN3C5A	BOLT
10	6	AN3C4A	BOLT
11	2	MS24694-C52	SCREW, CSK 100°
12	32	NAS1149C0332R	WASHER



NOTES:

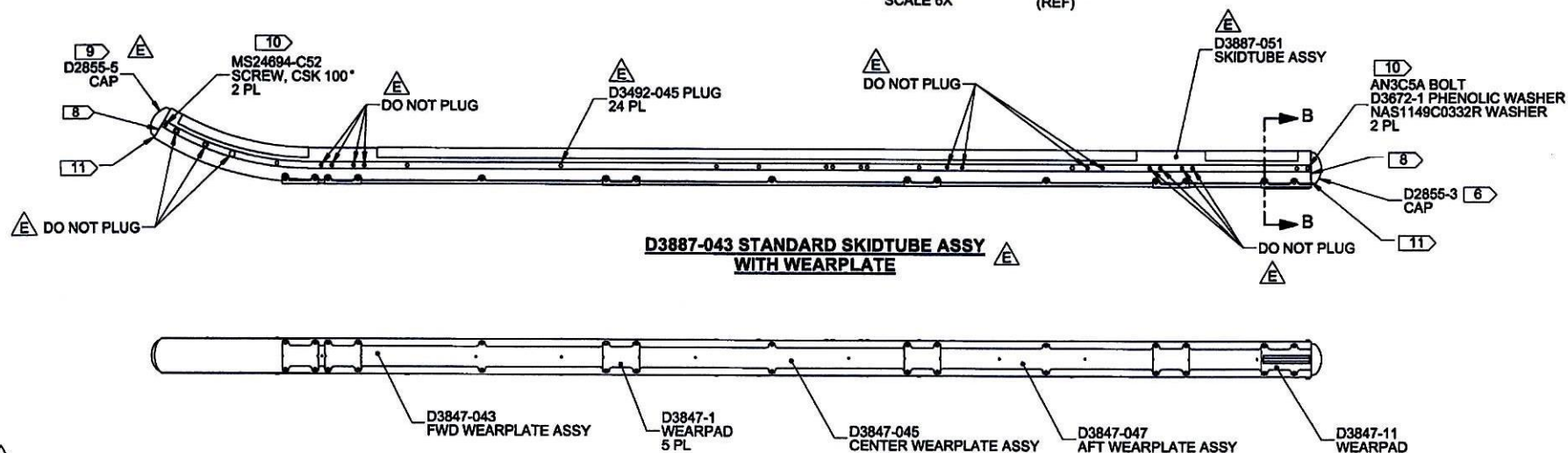
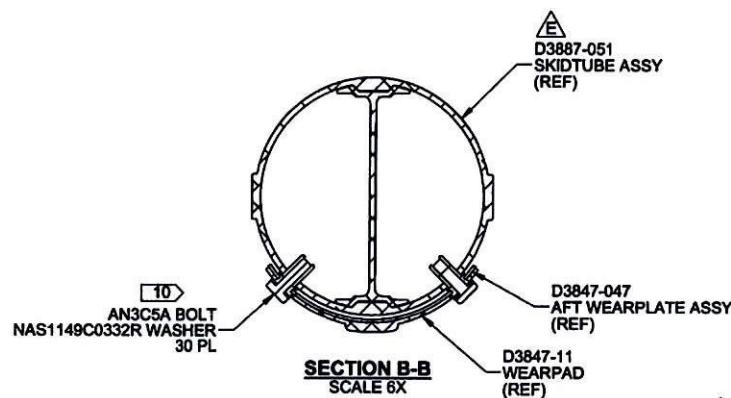
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 32.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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2017-05-08

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MFG. APPR.	DD	D3887	SHEET 2 OF 11
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DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3887-043	STANDARD SKIDTUBE ASSY WITH WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	24	D3492-045	PLUG ASSY
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-047	AFT WEARPLATE ASSY
8	5	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3887-051	SKIDTUBE ASSY
11	1	ALS4-1032-225	INSERT
12	32	AN3C5A	BOLT
13	2	MS24894-C52	SCREW, CSK 100°
14	32	NAS1149C0332R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 37.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

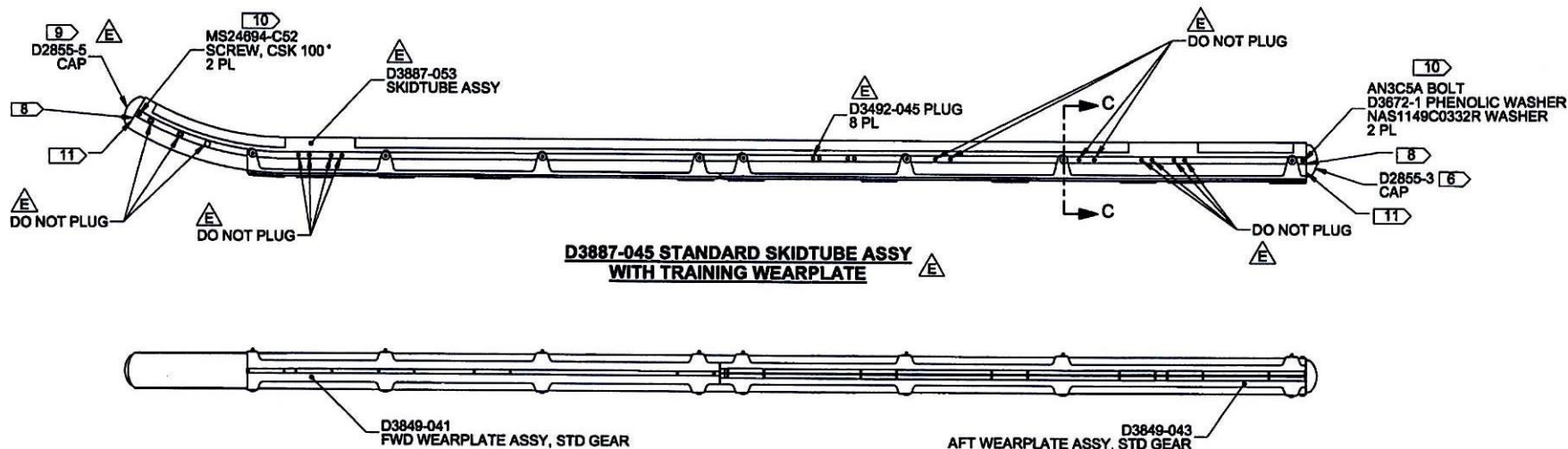
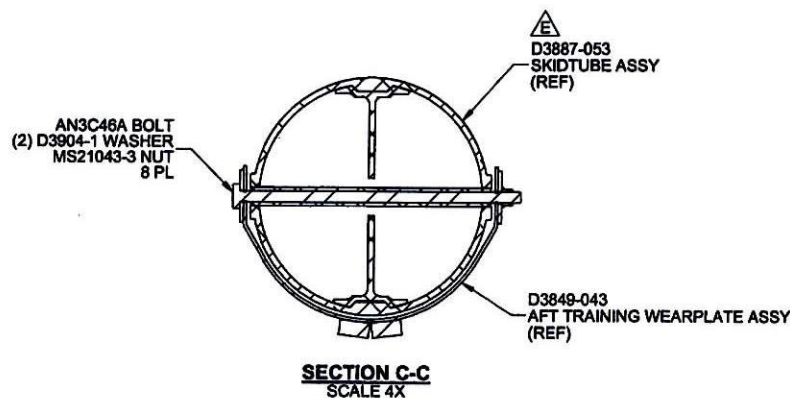
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ITEM	QTY	P/N	DESCRIPTION
	X	D3887-045	STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	8	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3849-041	FWD WEARPLATE ASSY, STD GEAR
6	1	D3849-043	AFT WEARPLATE ASSY, STD GEAR
7	1	D3887-053	SKIDTUBE ASSY
8	16	D3904-1	WASHER
9	1	ALS4-1032-225	INSERT
10	8	AN3C46A	BOLT
11	2	AN3C5A	BOLT
12	8	MS21043-3	NUT, SELF-LOCKING
13	2	MS24894-C52	SCREW, CSK 100°
14	2	NAS1149C0332R	WASHER



NOTES:

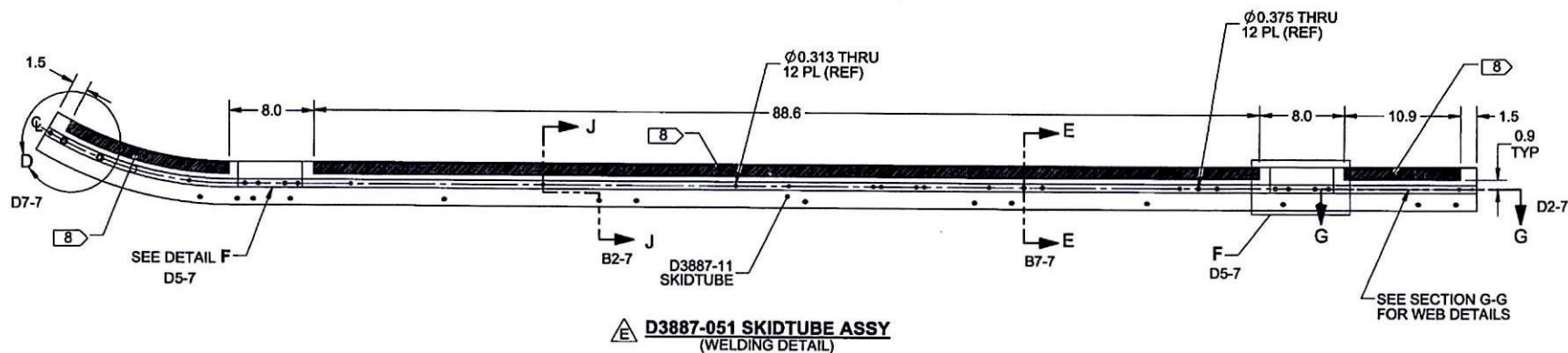
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 38.1 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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2017-05-08

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MFG. APPR.	DD	D3887	SHEET 4 OF 11
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ITEM	QTY	P/N	DESCRIPTION
	X	D3887-051	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-11	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER
6	30	ALS4-1032-130	INSERT



D3887-051 SKIDTUBE ASSY
(WELDING DETAIL)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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MFG. APPR.	DD	D3887	SHEET 5 OF 11
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DE APPR.	DS	A119 STD SKIDTUBE ASSY	
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ITEM	QTY -053	P/N	DESCRIPTION
	X	D3887-053	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-13	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER



D3887-053 SKIDTUBE ASSY
(WELDING DETAIL)

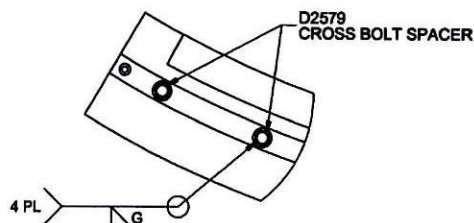
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

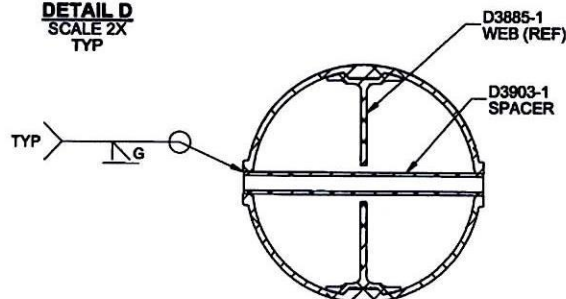
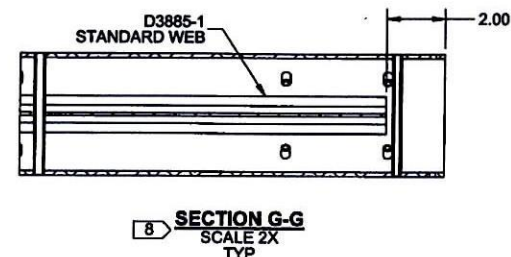
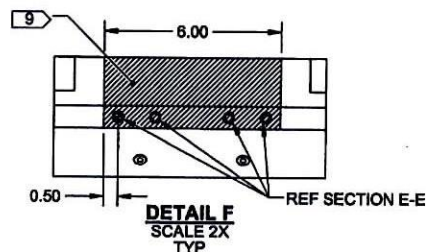
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DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 6 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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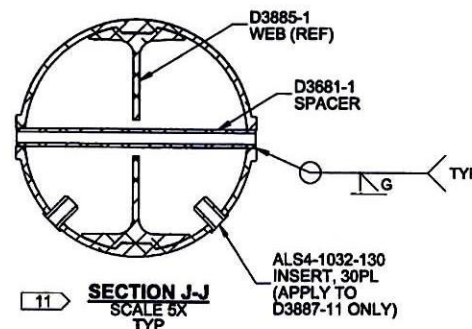


DETAIL D
SCALE 2X
TYP



SECTION E-E
SCALE 5X
TYP

(FOR 12X $\phi 0.375$ HOLES
PER SKIDTUBE)



(FOR 12X $\phi 0.313$ HOLES
PER SKIDTUBE)

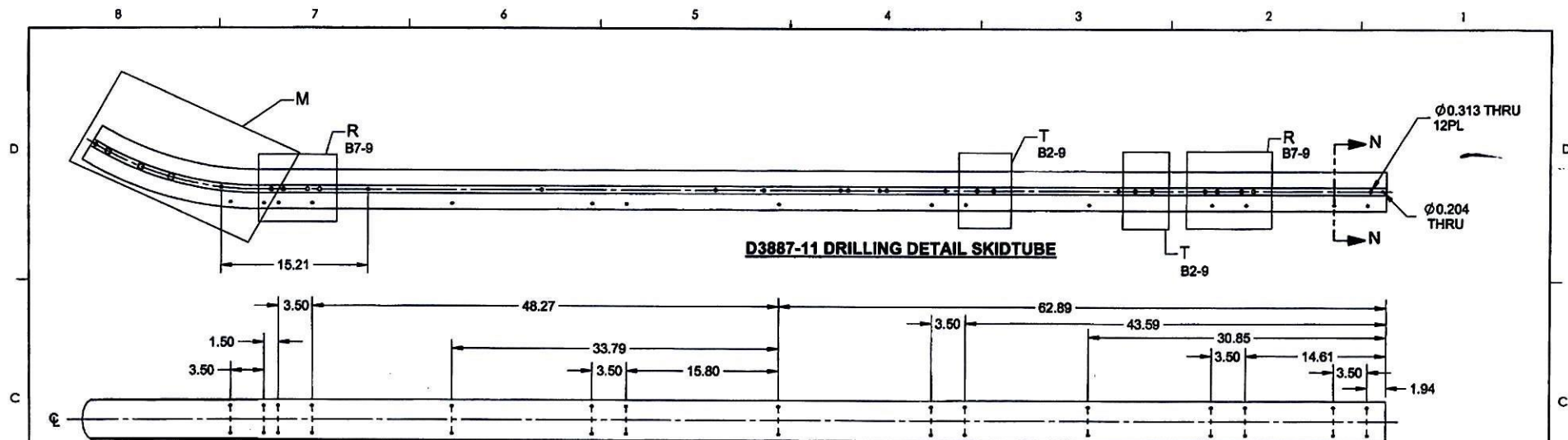
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) MASK THIS AREA AND DO NOT POWDER COAT
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C'BORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 11) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION J-J $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 12) WELD PER DART QSI 004

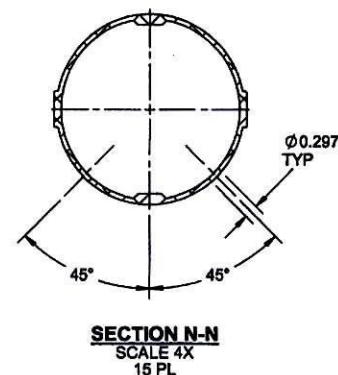
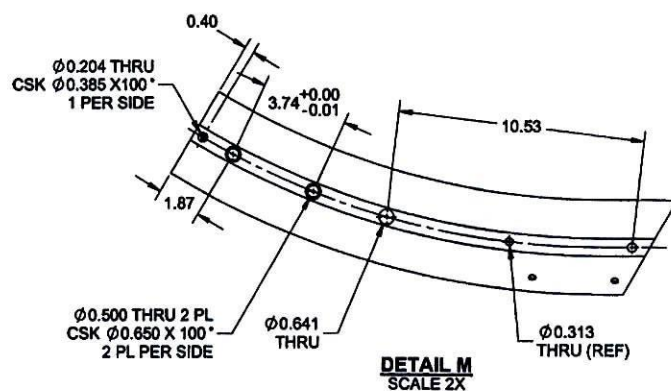
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WEARPAD/WEARPLATE HOLE PATTERN
FOR REFERENCE ONLY
DRILL USING DT8931 TEMPLATE



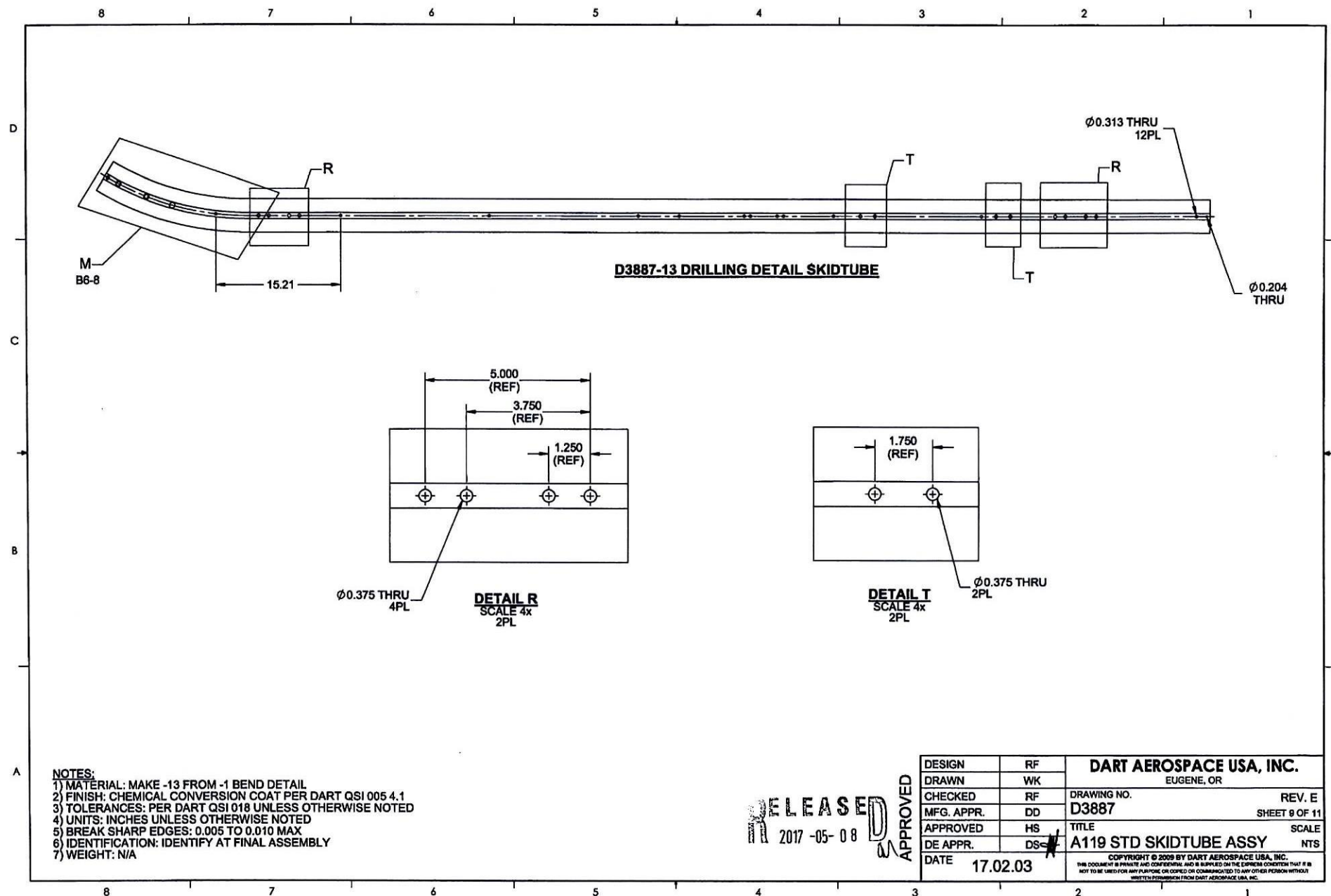
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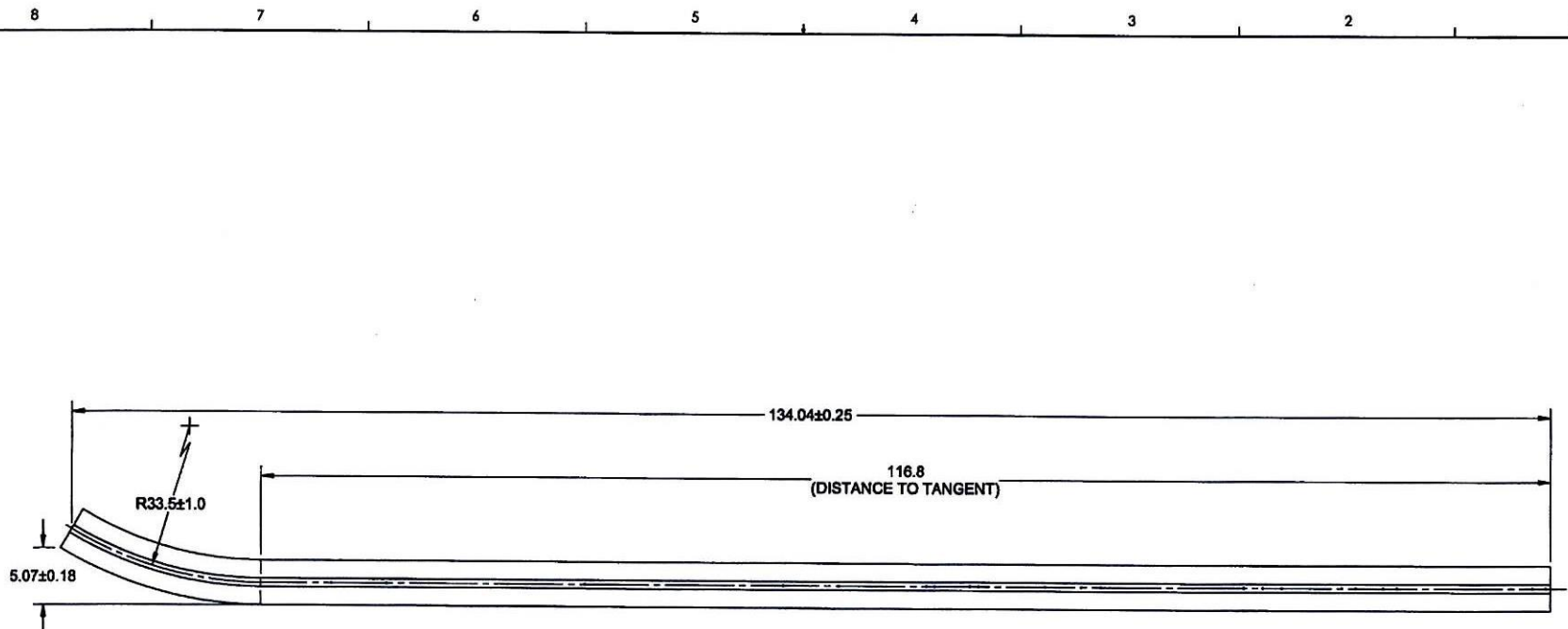
- 1) MATERIAL: MAKE -11 FROM -1 BEND DETAIL
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPAD/WEARPLATE INSERTS.

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DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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D3887-1 BEND DETAIL SKIDTUBE

NOTES:

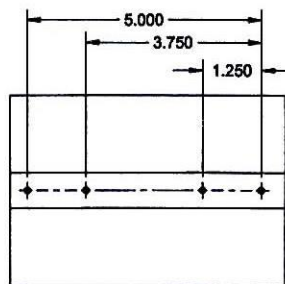
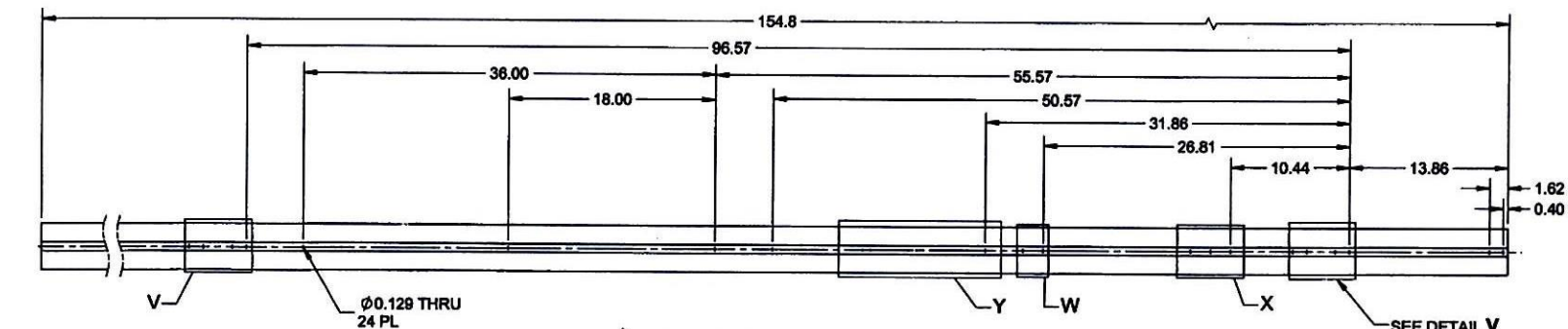
- 1) MATERIAL: MAKE -1 BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

RELEASE
2017-05-08

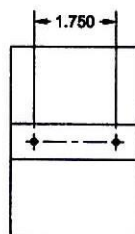
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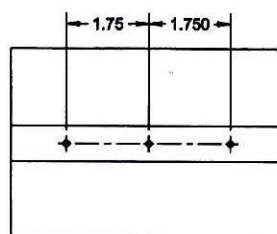
D3887-3 PILOT HOLE DETAIL SKIDTUBE



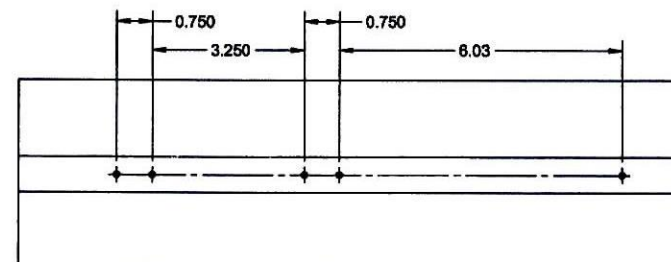
DETAIL V
SCALE 4X
2 PL



DETAIL W
SCALE 4X



DETAIL X
SCALE 4X



DETAIL Y
SCALE 4X

NOTES:

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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Time Sheet Adjustment